

Work Order ID 81366

81366

Page 1

March-13-12 1:38:58 PM

Item ID: D2620

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube, 206 Skidtube

Start Date: 13/03/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12/03/13

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2620

Rev B

100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

I-Bend extrusion as per Dwg D2620 using CNC Bending Machine program
206.A and Folio Ft0082- Cut Fwd end of tube as per Dwg D2620

10 6 GF/De 12-3-14

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

DP 12-3-16

120

Identify as per dwg & Stock Location: 4/6

0.00

120

Packaging

Memo

0.00

Packaging

De 12/03/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81366***81366***

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/3/16 [Signature]

012-03-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

March-13-12 1:39:02 PM

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Work Order ID: 81366

81366

Parent Item: D2620

D2620

Parent Item Name: Skidtube, 206 Skidtube

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP D02.07.26Change Dwg to rev.B; Updated LocationRF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-1-160

Manufactured

No

100

Each

122.0000

1

10

D2600-1-160

**

10

CF 12.3-14

Extrusion Round 3" 206

Location

Loc Qty

Loc Code

LG

122

43969

2

59875

1

68284

37

76913

82

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

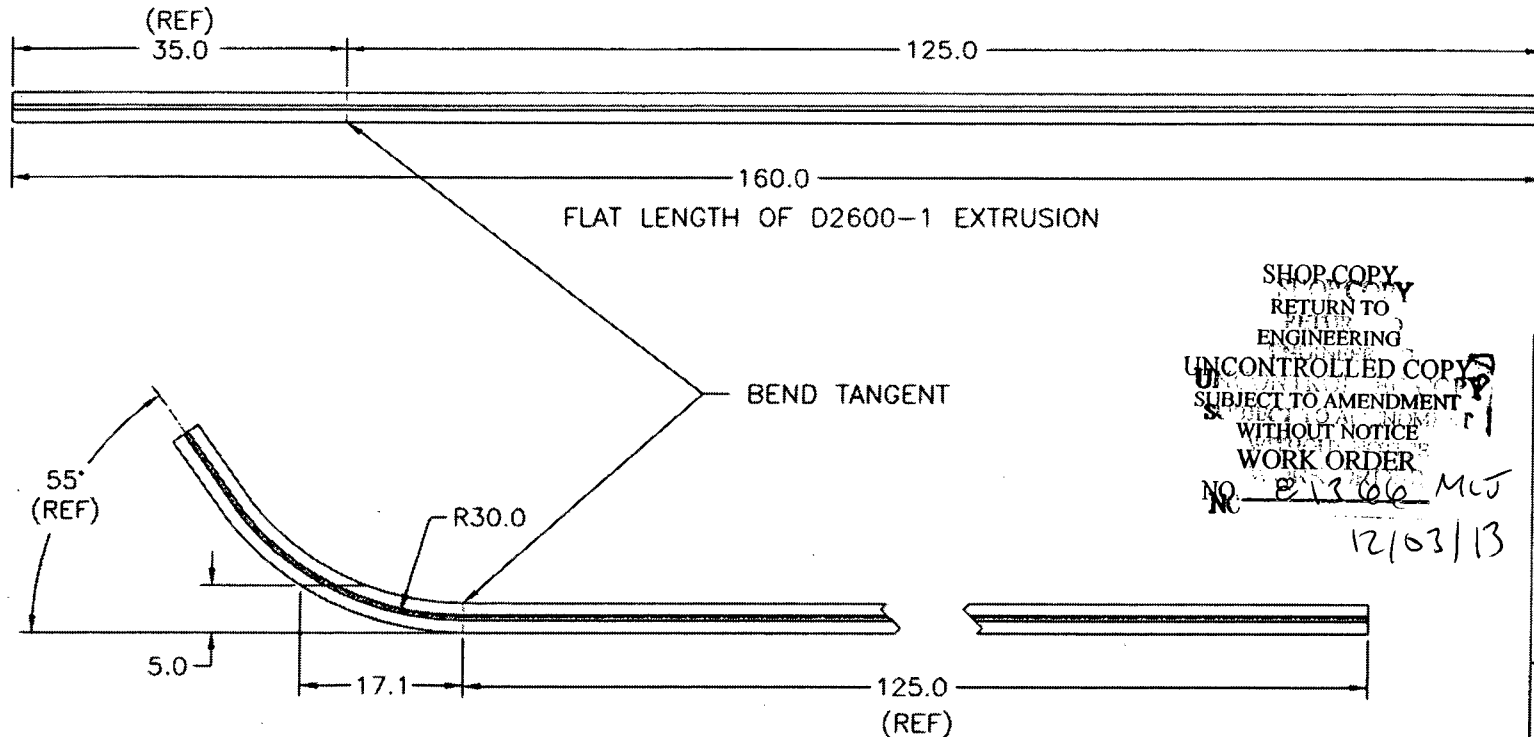
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NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING

DART



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 21306 MCT
12/03/13

DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.
NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND.
TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND.
TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

RELEASED
44-04-15 DS

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE		TITLE
99.09.10		206 SKIDTUBE BENDING CONTROL
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING
		SCALE
		1:20
		SHEET 1 OF 1
		REV. B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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